

Date: Thursday, 9/20/2007 3:26:47 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROTECTOR RH	<b>ENGINEERING APPROVAL</b> <i>UNDER REVIEW</i> 07.10.24
Job Number : 34740	Part Number : D32803	
Estimate Number : 11225	Drawing Number : D3280 REV B	
P.O. Number :	Project Number : N/A	
This Issue : 9/20/2007 S.O. No. :	Drawing Revision : B	
Prsht Rev. : NC	Material :	
First Issue : 1/1 Type : THERMOFORMING	Due Date : 9/27/2007	Qty: 5 Um: Each
Previous Run : 30769		
Written By :		
Checked & Approved By : <i>[Signature]</i>		
Comment : Est Rev: A 04.07.01 New issue KJ/JLM		
Est RevB 07.09.12 Thermoform in house DL		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	F6002 701	lexan black
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Comment: Qty.: 4.3600 sf(s)/Unit Total: 21.8000 sf(s)  
 lexan black .125"

Material Batch # ~~103735~~ *PTO.*  
 105952 *x6*

*2x 07.10.10 DL*  
*07.10.25 DL*

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

*x6*

*07.10.10 DL*  
*07.10.25 DL*

3.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 012

Dwg. Rev. B  
 Folio Rev. B

*x2 07.10.10 DL PTO-*  
*x6 07.10.10 DL*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*DL 07.10.24*  
*DL 07.10.25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3280-3 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/10/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>34740</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07.10.10</u>	<u>3</u>	<u>2 PARTS NOT FORMED. PROPERLY PARTS SCRAP R.C. Have template loss too quickly</u>	<u>PS1012</u>	<u>SCRAP 2 PARTS. SCRAP / destroy and replace</u>	<u>07.10.25 the</u>	<u>PS1012</u>	<u>PS1012</u>	<u>PS1012</u>
<u>07/10/07</u>		<u>2 parts not flat and have a ball flat</u>	<u>LE 07.10.25 PS1012</u>	<u>SCRAP and destroy N/A</u>		<u>LE 07.10.25 PS1012</u>	<u>PS1012</u>	<u>PS1012</u>

NOTE: Date & initial all entries

Date: Thursday, 9/20/2007 3:26:47 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR RH

Job Number: 34740

Part Number: D32803

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



PTO

Comment: HAND FINISHING THERMOFORMING

Dr. 07.10.24

Dr. 07.10.25

1) Trim to Finished Dimensions

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Dr. 07.10.24

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1/8 07/10/25

8.0

PACKAGING 1

PACKAGING RESOURCE #1



ENGINEERING  
APPROVAL



ST.272  
LE 07.10.25  
07/11/01

Comment: PACKAGING RESOURCE #1

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.01

Job Completion



U 07.11.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3280-3 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 07/11/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>34740</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.10.24	SrD	16.0 15 18.18 12.26 15 12.06	LE 07.10.24 QSI042	Acceptable	LE 07.10.24	✓ 07/10/24	LE 07.10.24 QSI042	✓ 07/10/24

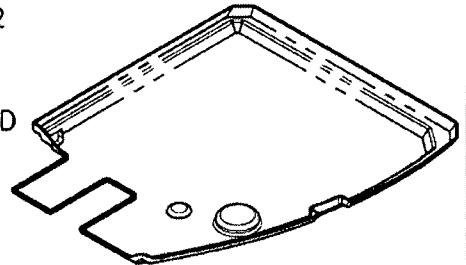
NOTE: Date & initial all entries



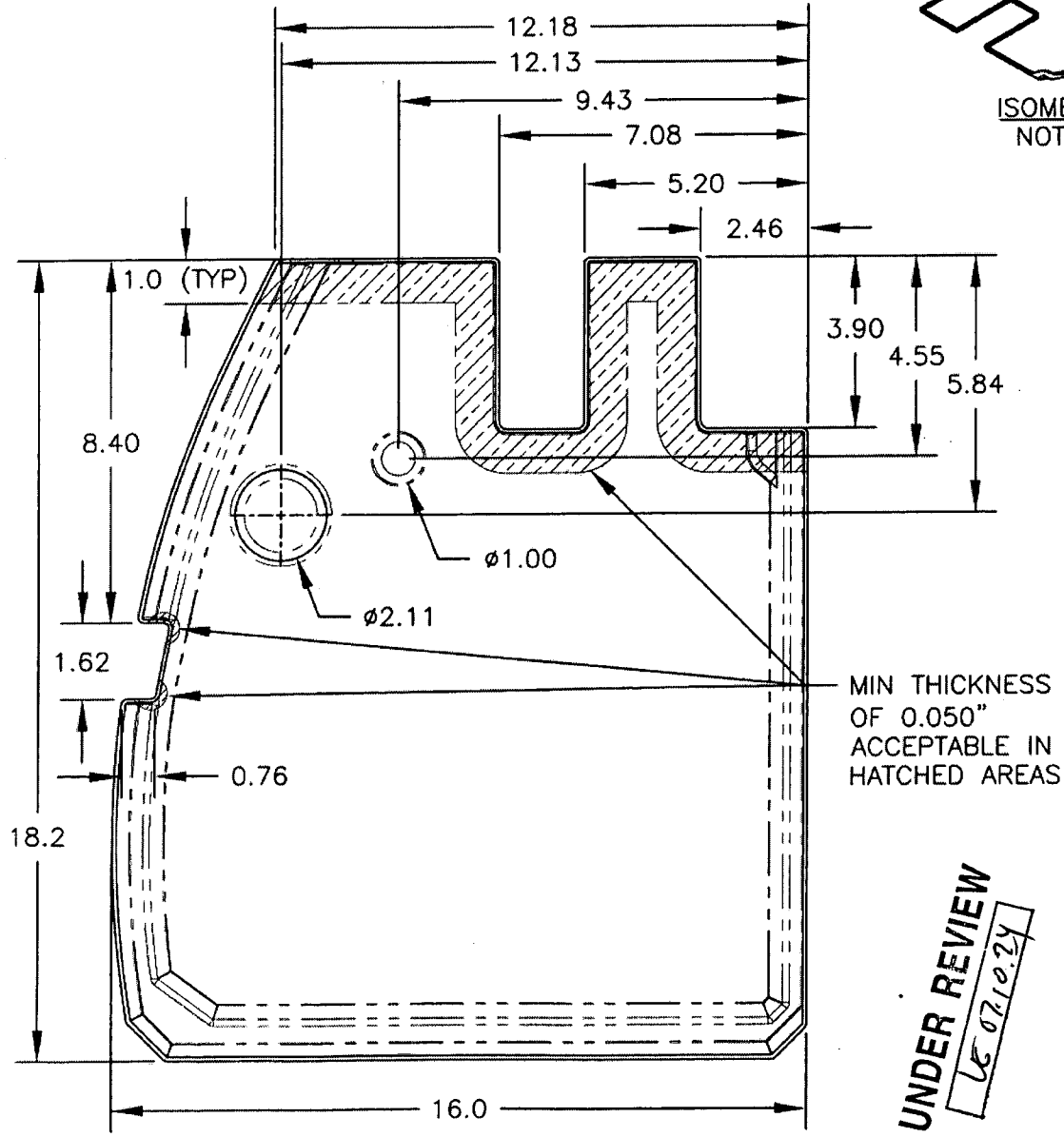
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3280	REV. B SHEET 1 OF 2
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:4
A	04.04.05	NEW ISSUE	
B	05.11.25	NOW LEXAN, DIMS AS MANUFACTURED	

D3280-1 FLOOR PROTECTOR

- 1) THERMOFORM USING MOLD D3280-1T1, TRIM USING D3280-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN



ISOMETRIC DETAIL  
NOT TO SCALE



UNDER REVIEW  
15 07.10.24

RELEASED  
15 12.01

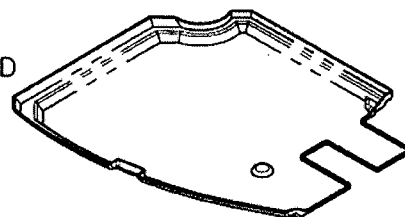
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34740



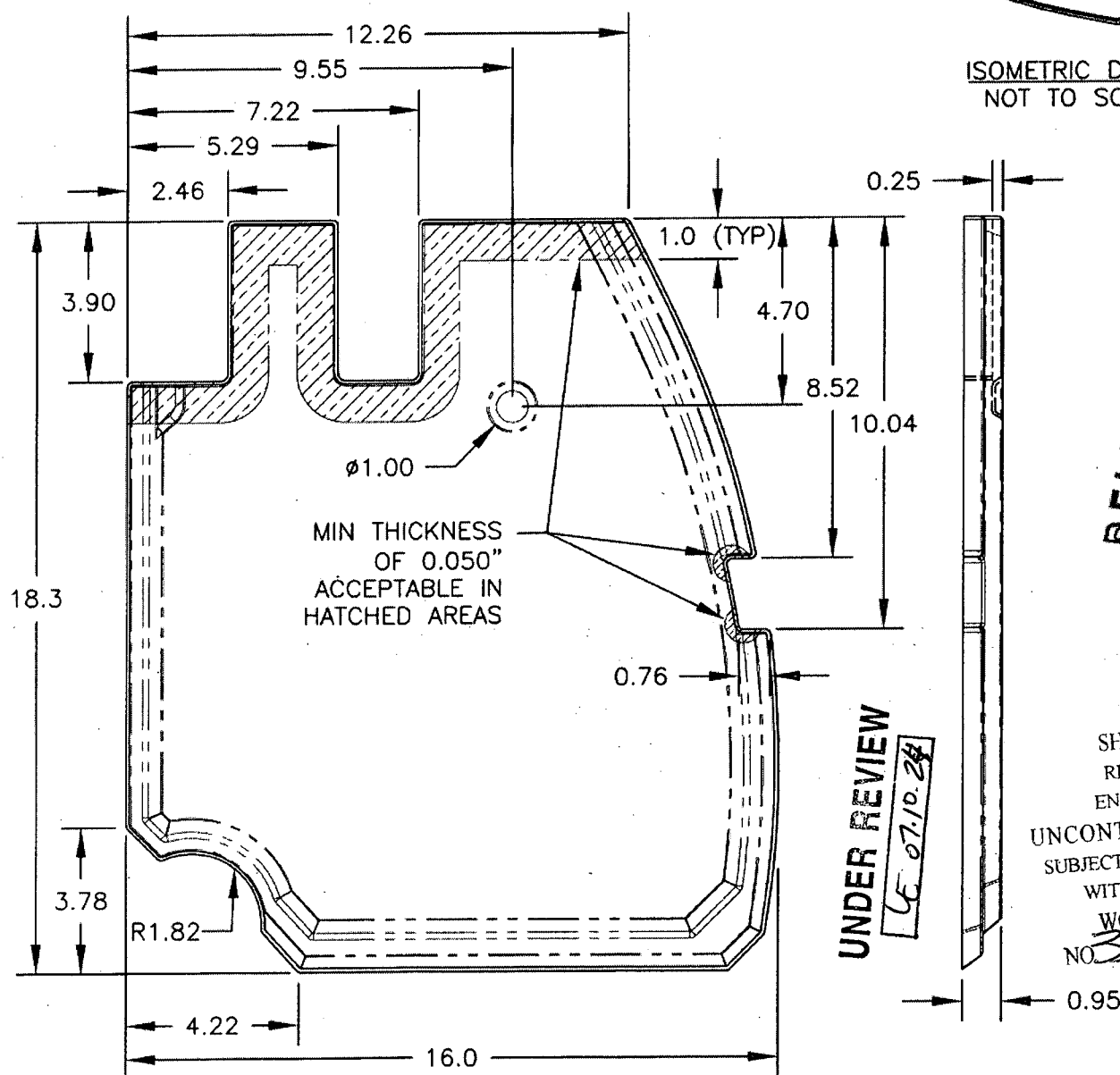
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3280	REV. B SHEET 2 OF 2
DATE 05.11.25		TITLE FLOOR PROTECTION	SCALE 1:4

### D3280-3 FLOOR PROTECTOR

- 1) THERMOFORM USING MOLD D3280-3T1, TRIM USING D3280-3T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080 EXCEPT AS SHOWN



ISOMETRIC DETAIL  
NOT TO SCALE



RELEASED  
05-12-01

UNDER REVIEW  
07.10.24

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WITHOUT NOTICE  
WORK ORDER  
NO. 34740

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DART AEROSPACE LTD		WORK ORDER:	34740
Description: R22 Floor Protector RH		Part Number:	D3280-3
Inspection Dwg: D3280	Rev: B	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article    ☐ Prototype

(Step 4) Thermoforming  
Visual Inspection Sign-off

Description	Initials
Inside Radii less than 3/16" go/no go	WJ
Acceptable shape definition	WJ
Acceptable texture retention	WJ
Free of visual flaws (bumps, cracks, voids, etc.	WJ

(Step 6) Trimming  
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3280 Rev. B and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	.1	18.281	✓		TAPE	
16.0	.1	15.8125		✓	TAPE	Acceptable LE 07.10.24
12.26	.030	12.0625		✓	TAPE	Acceptable LE 07.10.24
.95	.030	.955	✓		Caliper	
.25	.030	.251	✓		Caliper	

Measured by: WJ	Audited by: JS	Prototype Approval: LE
Date: 07.10.24	Date: 07.10.24	Date: 07.10.24

Rev	Date	Change	Revised by	Approved
		New Issue		